

Work Order ID 83939

April 27-12 2:52:55 PM

\*83939\*

Page 1

Item ID: K642-511 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: saddle kit 642-511  
 Start Date: 27/04/2012 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 11/05/2012 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/27 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D206-642	O

100	DOCUMENT CONTROL	0.00							
*100*									
DC	Memo	0.00							
Document Control	Create White labels per PPP K642-511	CHG004							

110	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

*110*									
Packaging	Memo	0.00							
Packaging									

120	QC4- 100% Inspect kits for completeness	0.00							
-----	---	------	--	--	--	--	--	--	--

*120*									
QC	Memo	0.00							
Quality Control									

DAS 16 12/05/13 JB

12/08/10 JB

DAS 16 12/05/13

x2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83939

\*83939\*

Page 2

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Item ID: K642-511

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: saddle kit 642-511

Stop \*NS2\*

Start Date: 27/04/2012 Start Qty: 2.00 \*2\*

Cust Item ID:

Required Date: 11/05/2012 Req'd Qty: 2.00 \*2\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
*130*	Packaging					2			OK 130
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP K642-511 Location: PK								
140	QC21- Final Inspection - Work Order Release	0.00							
*140*									
QC	Memo	0.00							
Quality Control									

MLJ 12/08/17

MF  
12-08-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 83939

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

\*83939\*

\*K642-511\*

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 2.00

Required Qty: 2.00

D2938-1

Manufactured No

110 Each

8.0000

1

2

✓

\*D2938-1\*

Saddle LH Out, 206

\*\*

82133

JB

50

Location

Loc Qty

Loc Code

ST421

2

79228

2

ST428A

6

78957

6

D2939-1

Manufactured No

110 Each

13.0000

0

2

\*D2939-1\*

Saddle LH In, 206

\*\*

83416

JB

50

Location

Loc Qty

Loc Code

ST421

2

79230

2

ST428A

11

74607

1

78956

4

82132

6

AN3C41A

Purchased No

110 Each

183.0000

8

16

✓

\*AN3C41A\*

BOLT

\*\*

122241

12/08/03

50

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

179

119673

19

120753

30

121013

50

121313

80

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 83939

\*83939\*

Parent Item: K642-511

\*K642-511\*

Parent Item Name: saddle kit 642-511

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 2.00

Required Qty: 2.00

D2652

Manufactured No

110

Each

351.0000

16

32

✓

\*\*

87617 JB

SP

\*D2652\*

Bushing

## Location

## Loc Qty

## Loc Code

FG

44

31985

44

ST013

307

73836

36

77134

15

81951

72

81953

184

MS21043-3

Purchased

No

110

Each

1,097.000

20

40

\*\*

121708 JB 12/08/03

SP

\*MS21043-3\*

Nut

## Location

## Loc Qty

## Loc Code

FG

72

103691

72

GA

124

120693

124

ST301

901

118077

2

118614

83

118686

30

119758

20

121255

766

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

Work Order ID: 83939

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Parent Item: K642-511

\*K642-511\*

Parent Item Name: saddle kit 642-511

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 2.00

Required Qty: 2.00

D3672-7 Manufactured No

110 Each 1,048.000 24 48 ✓

\*D3672-7\*

Phenolic Washer

\*\*

JB

SD

## Location

## Loc Qty

## Loc Code

ST060

1048

73488

16

76279

532

81872

500

76279

AN5C11A

Purchased No

110 Each 210.0000 8 16 ✓

\*AN5C11A\*

Bolt

\*\*

JB

SD

## Location

## Loc Qty

## Loc Code

FG

4

103715

4

ST337

206

119328

6

120423

50

121009

100

121556

50

121009

AN5C12A

Purchased No

110 Each 85.0000 8 ✓

\*AN5C12A\*

BOLT

\*\*

JB

12/08/03

SD

## Location

## Loc Qty

## Loc Code

FG

2

18918

2

ST338

83

119328

8

120518

50

121349

25

120518

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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\*83939\*

Parent Item: K642-511

\*K642-511\*

Parent Item Name: saddle kit 642-511

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 2.00

Required Qty: 2.00

AN5C13A

Purchased

No

110

Each

209.0000

4

8

\*AN5C13A\*

BOLT

\*\*

Location

Loc Qty

Loc Code

ST338

209

118983

9

119537

100

120562

100

119537

AN960C516L

NAS1149C0532

Purchased

No

110

Each

0.0000

8

16

\*AN960C516I \*

WASHER

\*\*

119736

AN4C6A

Purchased

No

110

Each

111.0000

12

24

\*AN4C6A\*

Bolt

\*\*

121657

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

107

116704

2

120423

105

D3672-3

Manufactured

No

110

Each

430.0000

24

48

\*D3672-3\*

Phenolic Washer

\*\*

84361

12/08/03

Location

Loc Qty

Loc Code

ST060

430

64176

153

83238

277

AN960C416L

NAS1149C0432B

Purchased

No

110

Each

0.0000

24

48

\*AN960C416I \*

WASHER

\*\*

121255

April-27-12 2:53:00 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
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Page 6

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\*83939\*

Parent Item: K642-511

\*K642-511\*

Parent Item Name: saddle kit 642-511

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 2.00

Required Qty: 2.00

MS21043-4

Purchased

No

110

Each

1,336.000

26

✓

\*MS21043-4\*

Nut

\*\*

122452 JB

## Location

## Loc Qty

## Loc Code

FG

40

104603

40

ST301

1296

119546

213

120308

83

121162

1000

D3407-043

Manufactured

No

110

Each

29.0000

2

✓

\*D3407-043\*

Tow Ring

\*\*

1786919 JB  
1785478

## Location

## Loc Qty

## Loc Code

ST420

9

79232

9

ST463

20

68339

2

77504

12

78841

6

D3456-1

Manufactured

No

110

Each

194.0000

2

✓

\*D3456-1\*

Washer

\*\*

JB 12/08/13

## Location

## Loc Qty

## Loc Code

FG

7

25701

7

ST044

187

80252

1

81876

86

83584

100

83584

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 7

Work Order ID: 83939

\*83939\*

Parent Item: K642-511

\*K642-511\*

Parent Item Name: saddle kit 642-511

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 2.00

Required Qty: 2.00

D2712

Manufactured No

110 Each

867 0000

10 20 ✓

\*D2712\*

Set Screw

\*\*

JB

*[Handwritten signature]*

Location

Loc Qty

Loc Code

FG

50

29962

50

ST017

817

79585

367

81871

200

83559

250

83559

D3457-1

Manufactured No

110 Each

67.0000

2 4 ✓

\*D3457-1\*

Washer

\*\*

85422 JB

*[Handwritten signature]*

Location

Loc Qty

Loc Code

FG

10

32409

10

ST044

57

67779

1

81977

56

D2934

Manufactured No

110 Each

36.0000

2 4 ✓

\*D2934\*

Saddle Spacer

\*\*

82014 JB 12/08/03

*[Handwritten signature]*

Location

Loc Qty

Loc Code

FG

6

31929

6

ST021

30

78802

30

April-27-12 2:53:00 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 8

Work Order ID: 83939

**\*83939\***

Parent Item: K642-511

**\*K642-511\***

Parent Item Name: saddle kit 642-511

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 2.00

Required Qty: 2.00

D2935

Manufactured No

110

Each

64.0000



4

\*\*

82013 JB

*[Handwritten signature]*

**\*D2935\***

Saddle Spacer

*S*

## Location

## Loc Qty

## Loc Code

FG

6

31793

6

ST021

58

78807

58

Purchased

No

110

Each

199.0000



18

\*\*

122491 JB 12/08/03

*[Handwritten signature]*

AN3C36A

**\*AN3C36A\***

BOLT

*S*

## Location

## Loc Qty

## Loc Code

FG

4

101261

4

ST353

195

116590

0

119083

2

119324

31

121013

15

121167

7

121276

15

121388

75

121389

50

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: K642-511

\*K642-511\*

Parent Item Name: saddle kit 642-511

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 2.00

Required Qty: 2.00

AN3C35A

Purchased

No

110

Each

99.0000

6

\*AN3C35A\*

BOLT

\*\* 24

JB

50

Location

Loc Qty

Loc Code

FG

4

18914

4

ST353

95

119449

50

121013

25

121313

20

121013

AN960C10L

NAS1149C0332

Purchased

No

110

Each

0.0000

24

48

\*AN960C10L\*

Washer

\*\* 24

122063 JB

50

washer

D3396-3

Manufactured

No

110

Each

27.0000

24

4

\*D3396-3\*

Spacer

\*\* 24

82073 JB

50

Location

Loc Qty

Loc Code

FG

10

26772

10

ST041

17

73349

17

D3672-1

Manufactured

No

110

Each

1,340.000

24

48

\*D3672-1\*

Phenolic Washer

\*\* 24

20

12/08/03

Location

Loc Qty

Loc Code

ST060

1340

72229

4

76277

336

80369

500

83608

500

80369 JB

April-27-12 2:53:00 PM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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\*83939\*

Parent Item: K642-511

\*K642-511\*

Parent Item Name: saddle kit 642-511

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 2.00

Required Qty: 2.00

AN5C35A

Purchased

No

110

Each

47.0000

\*AN5C35A\*

Bolt

## Location

## Loc Qty

## Loc Code

ST340

47

118451

22

119749

25

AN5C15A

Purchased

No

110

Each

77.0000

\*AN5C15A\*

Bolt

## Location

## Loc Qty

## Loc Code

ST338

77

118191

3

120422

30

120833

19

121162

25

AN5C32A

Purchased

No

110

Each

107.0000

\*AN5C32A\*

## Location

## Loc Qty

## Loc Code

FG

4

18918

4

ST339

103

117407

3

119035

50

120578

50

\*\*

\*\*

\*\*

2

2

4

118451

~~720422~~

121162

119035

JB

JB

JB

12/08/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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\* Parent Item: K642-511

\*K642-511\*

Parent Item Name: saddle kit 642-511

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 2.00

Required Qty: 2.00

AN5C34A

Purchased

No

110

Each

60.0000

\*\* 2

4

\*AN5C34A\*

Location

Loc Qty

Loc Code

FG

2

18918

2

ST339

58

119083

3

119530

30

121013

25

119530

MS21043-5

Purchased

No

110

Each

629.0000

\*\* 4

8

\*MS21043-5\*

Location

Loc Qty

Loc Code

FG

20

101418

20

ST300

4

112314

4

ST301

605

116548

100

118159

81

119307

25

119537

200

121283

199

119537

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-511	SKIDTUBE INSTALLATION, LH
		X								D206-642-512	SKIDTUBE INSTALLATION, RH
			X							D206-642-515	SKIDTUBE INSTALLATION, LH
				X						D206-642-516	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-541	SKIDTUBE
						X				D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
							X			D206-642-549	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-551	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D3274-041	SKIDTUBE ASSEMBLY
1								1		D4362-041	SKIDTUBE ASSEMBLY
3					1			1		D2646	* AFT CAP <sup>(1)</sup>
4					2			2		AN3C4A	* BOLT <sup>(1)</sup>
5A					2			2		NAS1149C0332R	* WASHER <sup>(1)</sup> (OR AN960C10L)
5B					2			2		D3672-1	* WASHER (REPLACES NAS1515H3L) <sup>(1)</sup>
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3C41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21043-3	NUT
12B	16	16	16	16						D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4	4	4						AN5C11A (or AN5C12A)	* BOLT <sup>(2)</sup>
14	4	4	4	4						AN5C11A (or AN5C13A)	* BOLT <sup>(2)</sup>
15A	8	8	8	8						NAS1149C0532R	WASHER (OR AN960C516L)
15B	8	8	8	8						D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12	12	12						AN4C6A	BOLT
17A	24	24	24	24						D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24	24	24						NAS1149C0432R	WASHER (OR AN960C416L)
18	12	12	12	12						MS21043-4	NUT
20A					9	9				D3537-1	* WEARPAD <sup>(1)</sup> (REPLACES D2648-3)
21A					1	1				D3537-3	* WEARPAD <sup>(1)</sup> (REPLACES D3429-1)
22A					1	1				D3535-15	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-15)
22B					1	1				D3536-15	* GASKET <sup>(1)</sup>
23A					1	1				D3535-23	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-23)
23B					1	1				D3536-23	* GASKET <sup>(1)</sup>
24A					1	1				D3535-39	* WEARSHOE <sup>(1)</sup> (REPLACES D3287-1)
24B					1	1				D3536-39	* GASKET <sup>(1)</sup>
25A					1	1				D3535-35	* WEARSHOE <sup>(1)</sup> (REPLACES D2656-35)
25B					1	1				D3536-35	* GASKET <sup>(1)</sup>
26A			8	8	78	78	8			AN3C4A	* BOLT <sup>(1)</sup>
26B			8	8	78	78	8			NAS1149C0332R	* WASHER <sup>(1)</sup> (OR AN960C10L)
26C			8	8	78		8			ALS7-1032-130	* INSERT <sup>(1)</sup> (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34			1	1	1					AN4C5A	BOLT
35			1	1	1					NAS1149C0463R	WASHER (OR AN960C416)
36			1	1	1					D3413-1	RING
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER

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ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
40									2	D3414-041	LUG ASSEMBLY (GHW)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)
50	9	9	3	3						AN3C36A	BOLT
51	3	3	3	3						AN3C35A	BOLT
52	24	24	12	12						NAS1149C0332R	WASHER (OR AN960C10L)
53	24	24	12	12						D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12	6	6						MS21043-3	NUT
55	2	2	2	2						D3396-3	SPACER
56A	1	1	1	1						AN5C35A	BOLT
56B	1	1	1	1						AN5C15A	BOLT
60	2	2	2	2						AN5C32A	BOLT
61	2	2	2	2						AN5C34A	BOLT
62	4	4	4	4						MS21043-5	NUT
80								1	1	D4368-041	FWD WEARPLATE ASSY
81								1	1	D4368-043	AFT WEARPLATE ASSY
82A								1	1	D4383-1	WEARPAD
82B								1	1	D4383-3	WEARPAD
83								20	20	D3873-3	BUSHING
84									24	D3411-3	WASHER
85								2		D3275-1	SPACER
86A								6	6	AN3C40A	BOLT
86B								2	2	AN3C37A	BOLT
86C								2	2	AN3C36A	BOLT
87								10	10	MS21043-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 OR D4362-041 ASSEMBLY ABOVE  
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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